

Date: Thursday, 10/25/2007 2:27:26 PM  
 User: Kim Johnston

## Process Sheet

46

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number : 35398	
Estimate Number : 12779	
P.O. Number : N/A	Part Number : D350600242
This Issue : 10/25/2007 S.O. No. : N/A	Drawing Number : IIN REV.C PG11,18-21
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : N/A
Previous Run : 35396	Material :
Written By : <u>10/07/10/25</u>	Due Date : 11/15/2007 Qty: 1 Um: Each
Checked & Approved By : <u>10/07/10/25</u>	
Comment : Est Rev. A 07.03.07 new issue EC	
est rev B 07.04.16 reformat, D3188 rev.E EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



+DSI 9394  
 07.11.28  
 KJ

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

5 A10/66

2.0	D31862/M	Spacepod Door
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door

B 30083

ml 07/10/31

3.0	D31882/M	Spacepod Body
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Body

B 30089

ml 07/11/02

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

~~D3186-4~~

ml 07/10/31

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5 A10/31 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31872

Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3187-2

Floor

31836

SP

7.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: M105730

SP

7/10/30

8.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer - Countersunk

M 106150 x 8 ✓ ml07/11/00

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes in D3188-2 using drill jig DT8971

2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188

3-Deburr

4-Install inserts in D3188-2 as per Dwg D3188.

ml07/11/05

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/11/05 (1)

11.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

neoprene foam

batch: B 30632

ml07/10/30

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml07/11/05

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35398

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lock Nut  
batch: 34192 SP

14.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BALL STUD

30210 SP

15.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Washer  
BATCH: M104156 SP

16.0

D35672

DECAL



Comment: Qty.: ~~1.0000~~ Each(s)/Unit Total : ~~1.0000~~ Each(s) OK1  
DECAL  
batch: 31128 SP

17.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pick:  
Batch: 33486 SP

18.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Pick:  
Batch: M3459 SP

19.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HINGE BRACKET  
batch: 35454 7/10/30 SP

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35398

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch:

30630

SB

21.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch:

M104603

SB

PTO

22.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

M104625

SB

23.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch:

M105430

SB

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

\*\*\*\*This step separates hardware, previous steps is for body & floor\*\*\*\*

N/A m107/11/05

25.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch:

M104427

SB

26.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

M104625

7/10/30

SB

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-20	2.1.0	Screen MS526C832R24 was to short substitute with MS27039C08	LE 07.11.20 Q51042	Substitute with B M106298 and Buld M6956 AN960J08L washer. Provide DS1 to customer	LE 07.11.20		LE 07.11.20 Q51042	
				Put back in stock 4x AN526C832R24 screws	ml 07/11/20			

NOTE: Date & initial all entries



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Job Number: 35398

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M105164

SP

28.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M167130

SP

29.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: 30687

SP

30.0

D35672

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: 31128

SP

31.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: 32504

SP

32.0

D2585

Latch Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: 33487

SP

33.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: 28916

7/10/30 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35398

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M105108

SC

35.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100151

SC

36.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M104625

SC

37.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: 33942

SC

38.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: 33459

SC

39.0

D2228

Backing Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: 30679

SC

40.0—

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104603

7/10/30 SC

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 35398

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M105316 , M104625 ,

S4

42.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M105430 ,

S4

43.0

D35571

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: 32647 ,

S4

44.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M104603 9216 ,

S4

3/10/30

(X)

45.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M104603 ,

2/10/30

(X)

S4

46.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

A/R Hysol batch: M105573 expire date: 09/05/2008

A/R Milled fibres batch: M100859

2-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: M102565

*[Handwritten signature]*

X1

*[Handwritten signature]*  
m107/12/20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/15	4B	Screws in 526 C132 P2A are too short		See NCR and Rework				

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Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 35398

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/11/21 01 R4

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch:

M106060

M-L 07/11/21

49.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

5 07/11/22

50.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

\* 32423

SD 7/12/06

51.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

NIA

P4

52.0

D350600449

SWITCH RELOCATION KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

32369

53.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

batch:

32470

SD

54.0

D35471

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch:

32372

2/10/30 SD

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35398

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: 32450

SP

56.0

D35527

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: 32644

SP

57.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: 30210

SP

58.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M104156

SP

59.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: 134197

7/10/30 SP (12)

60.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/12/06

61.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: 15

PPP Rev: 7/12/06

SP (12)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35398

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

62.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
D 07.12.06

Job Completion



U 07.12.06

**Dart Aerospace Ltd**

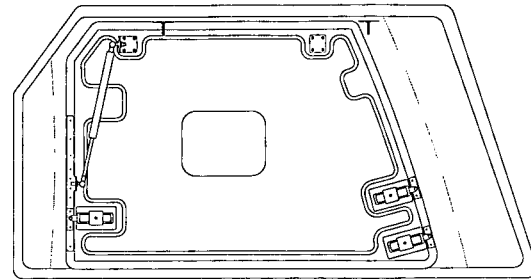
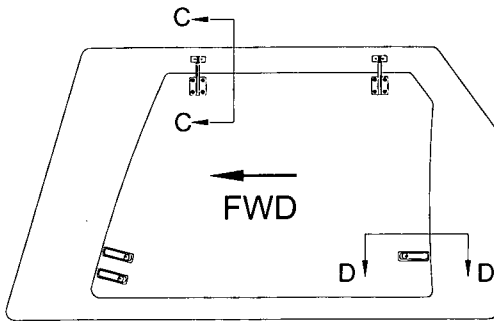
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

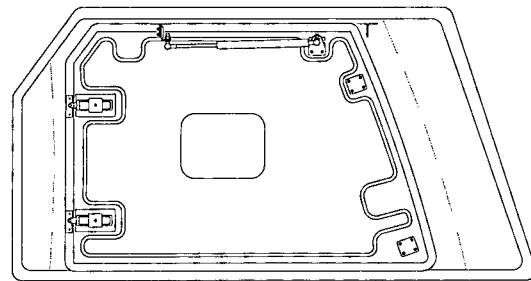
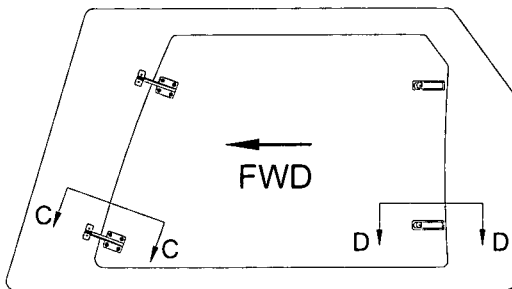
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

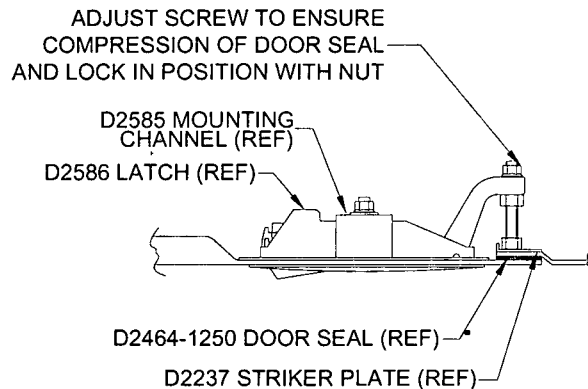
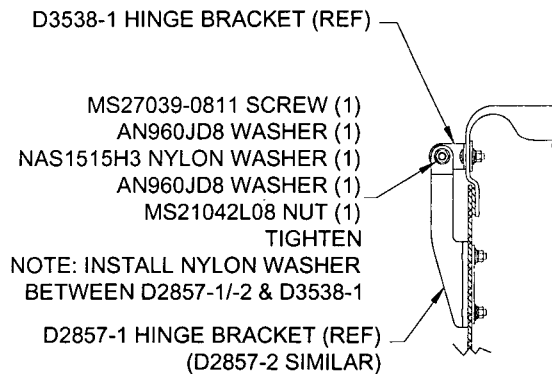
**NOTE:** Date & initial all entries



**FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



**FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



**SECTION 'C-C' HINGE**  
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)

**SECTION 'D-D' LATCH**

3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

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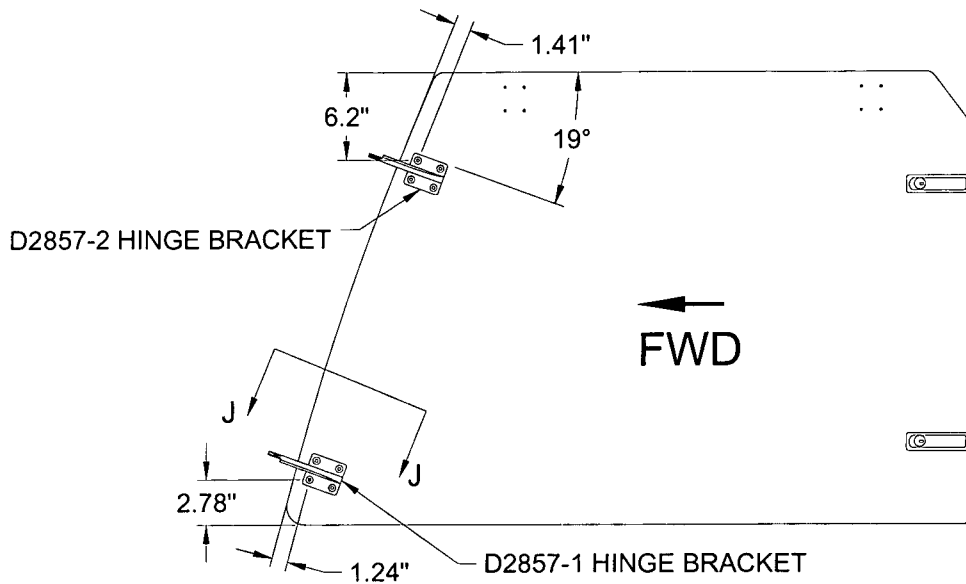
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WORK ORDER

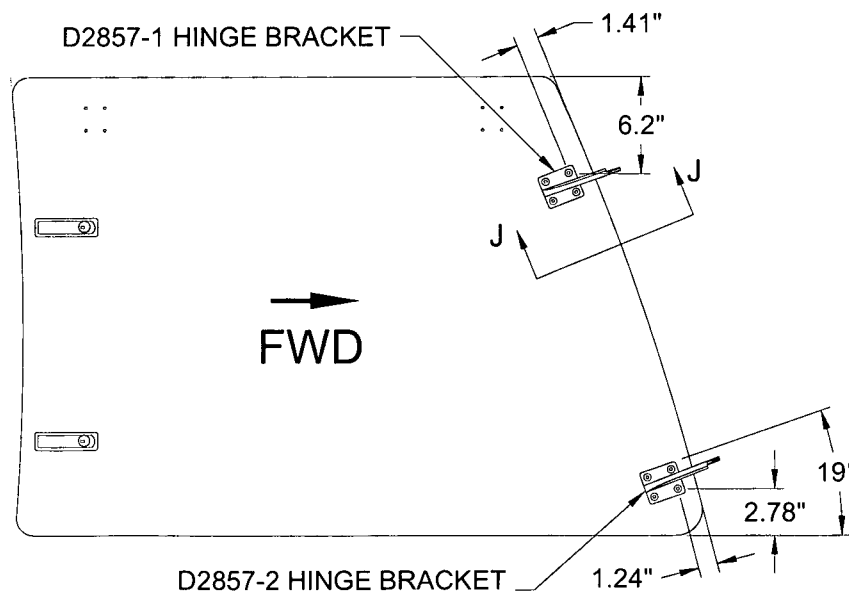
NO. 35398



- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the  $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

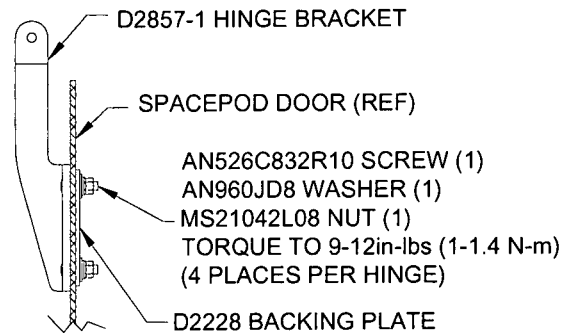


**FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR**



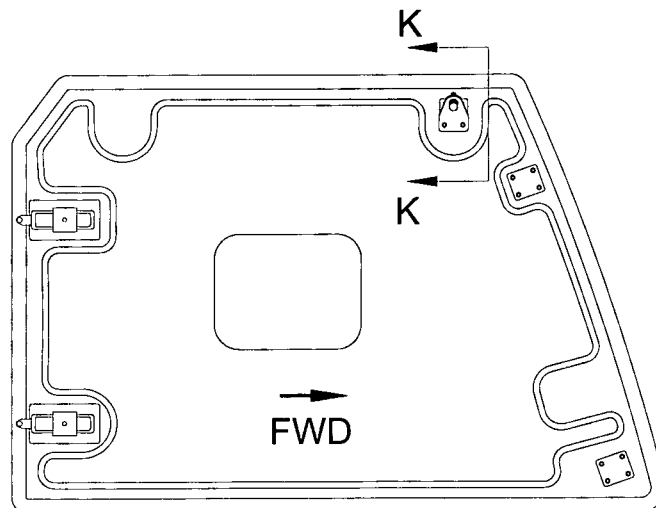
**FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR**

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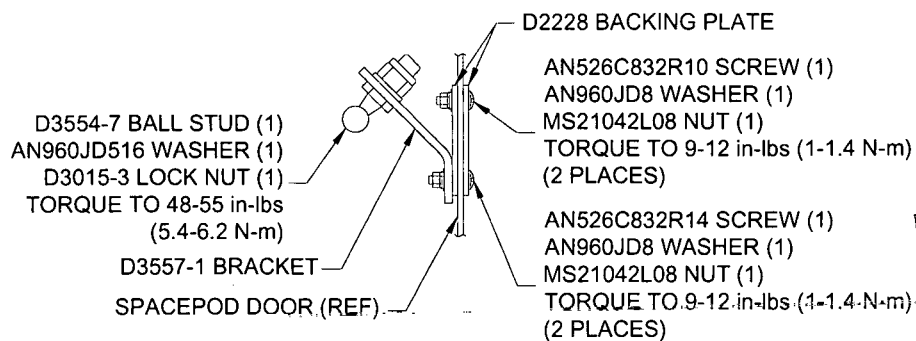


**SECTION 'J-J' HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.



**FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR**  
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



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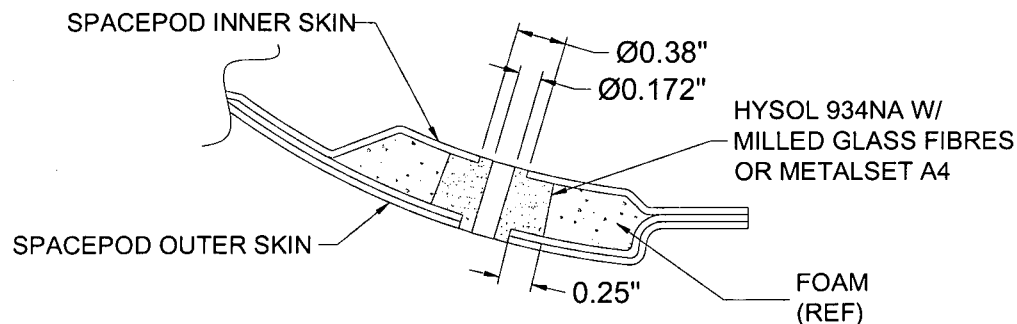
**SECTION 'K-K'**

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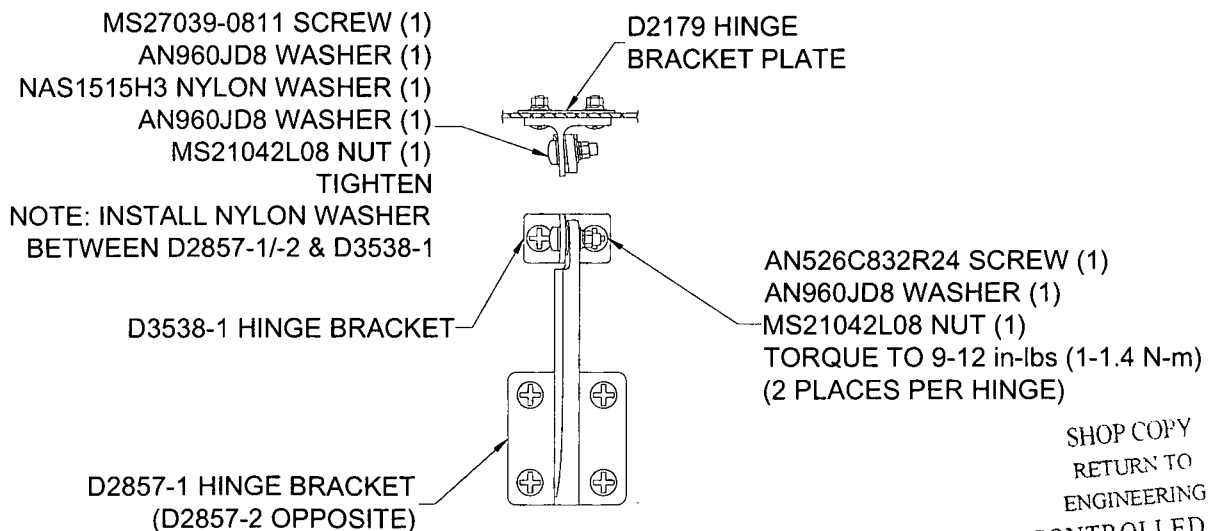
Revision: C  
Date: 07.02.20



- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
  - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
  - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
  - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
  - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).



**FIGURE 17(a). COMPOSITE MODIFICATION**



**FIGURE 17(b). HINGE BRACKET INSTALLATION**  
(D2857-1-SHOWN; D2857-2 OPPOSITE)

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NO. 35398

Date: Thursday, 12/21/2006 12:55:07 PM  
 User: Kim Johnston

## Process Sheet

35398

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD DOOR RH  
 Job Number : 30083  
 Estimate Number : 12599  
 P.O. Number : N/A Part Number : D31862M  
 This Issue : 12/21/2006 S.O. No. : N/A Drawing Number : D3186 REV *SC* *UE* 07-07-18  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *MA* Type : PURCHASED PARTS Drawing Revision : *SC* *UE* 07-07-18  
 Previous Run : 30038 Material : *MA*  
 Due Date : 2/15/2007 Qty: 1 Um: Each  
 Written By : *JA*  
 Checked & Approved By : *JA* 061221  
 Comment : Est Rev:A New Issue 06-12-04 ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *2771*

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

*C706112122**①**(42018)*

2.0 D31862P Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Spacepod Door

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

*CP 07/10/10*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186. Visual inspection. Check for void spot and pins.

*ml 07/10/31*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA**ml 07/10/31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/21/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/21/2006 12:55:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 30083

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
12/21/06

Job Completion



12/21/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

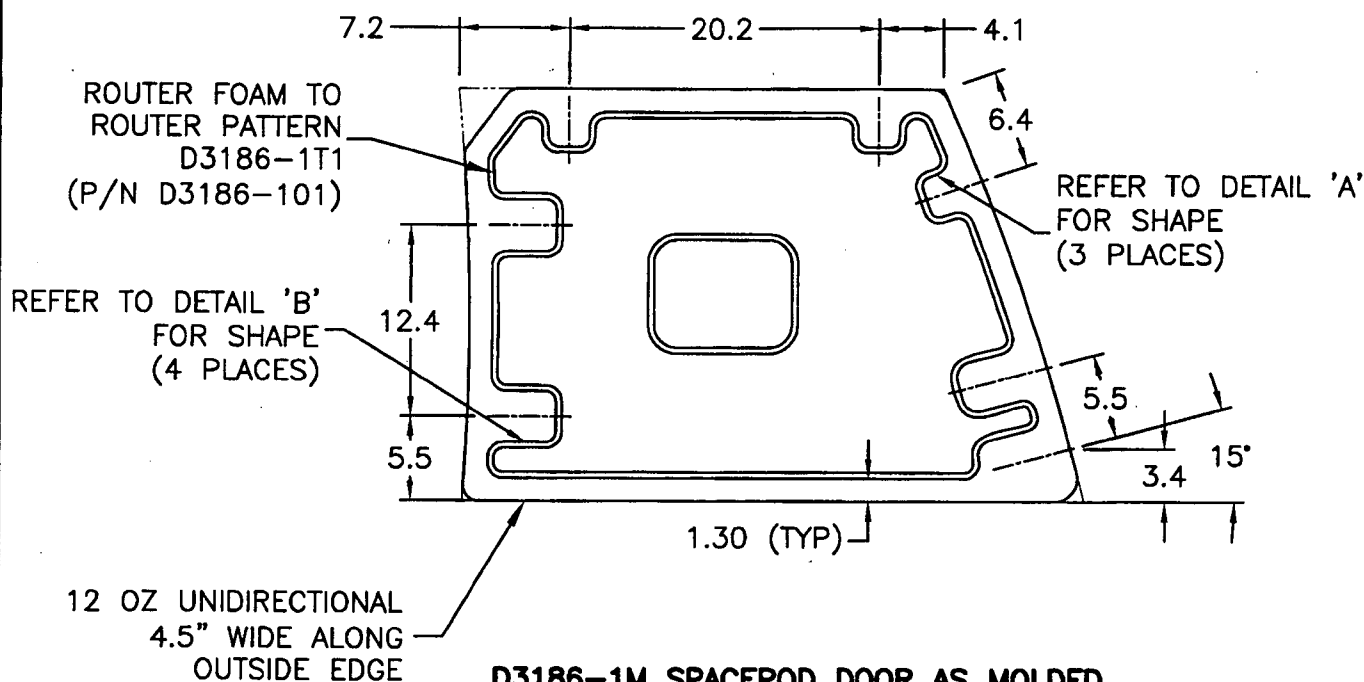
**NOTE:** Date & initial all entries

**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****RELEASED**  
06.12.22 H**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
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- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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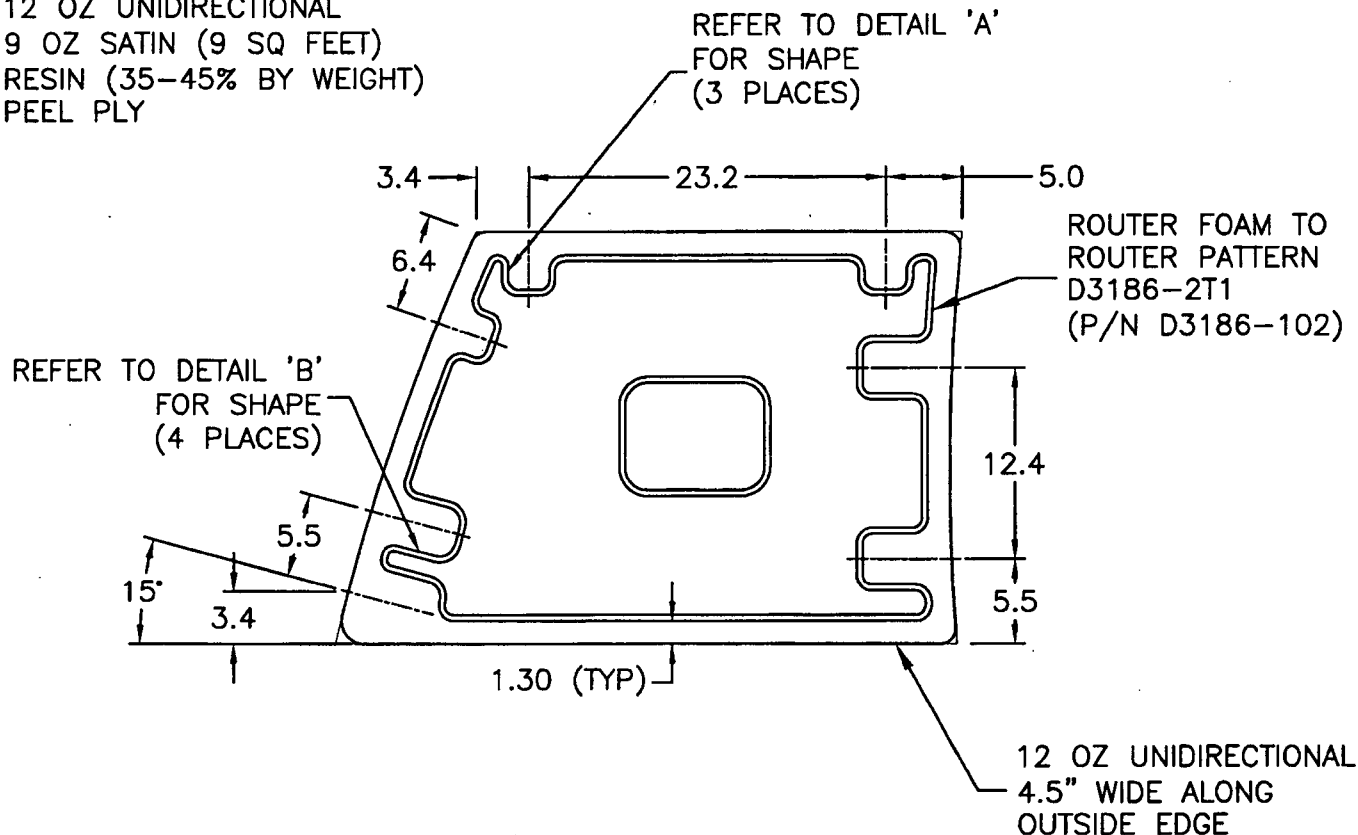


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DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

#### MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

RELEASED  
06.12.13



**D3186-2M SPACEPOD DOOR AS MOLDED**

#### NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
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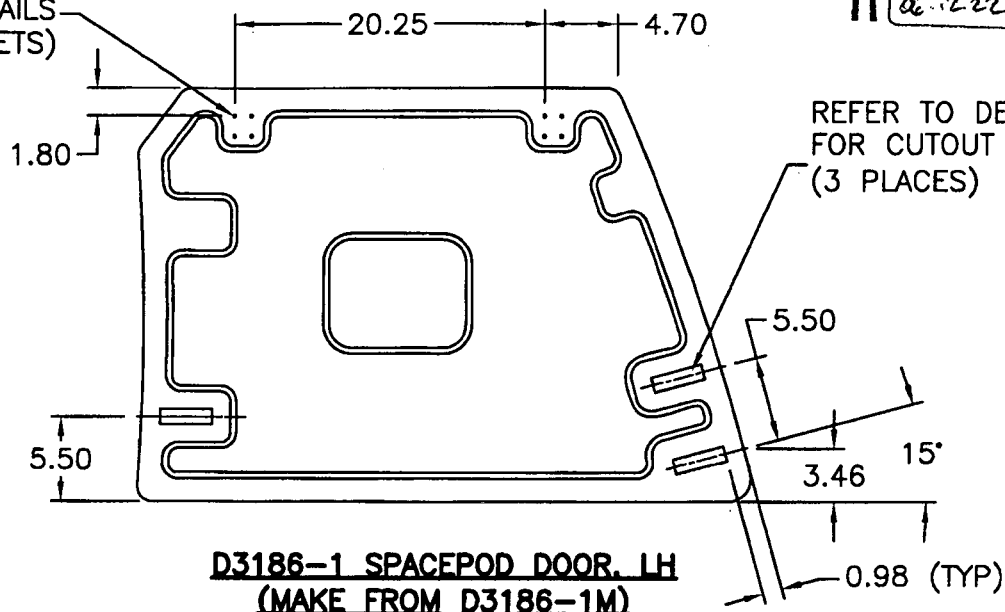
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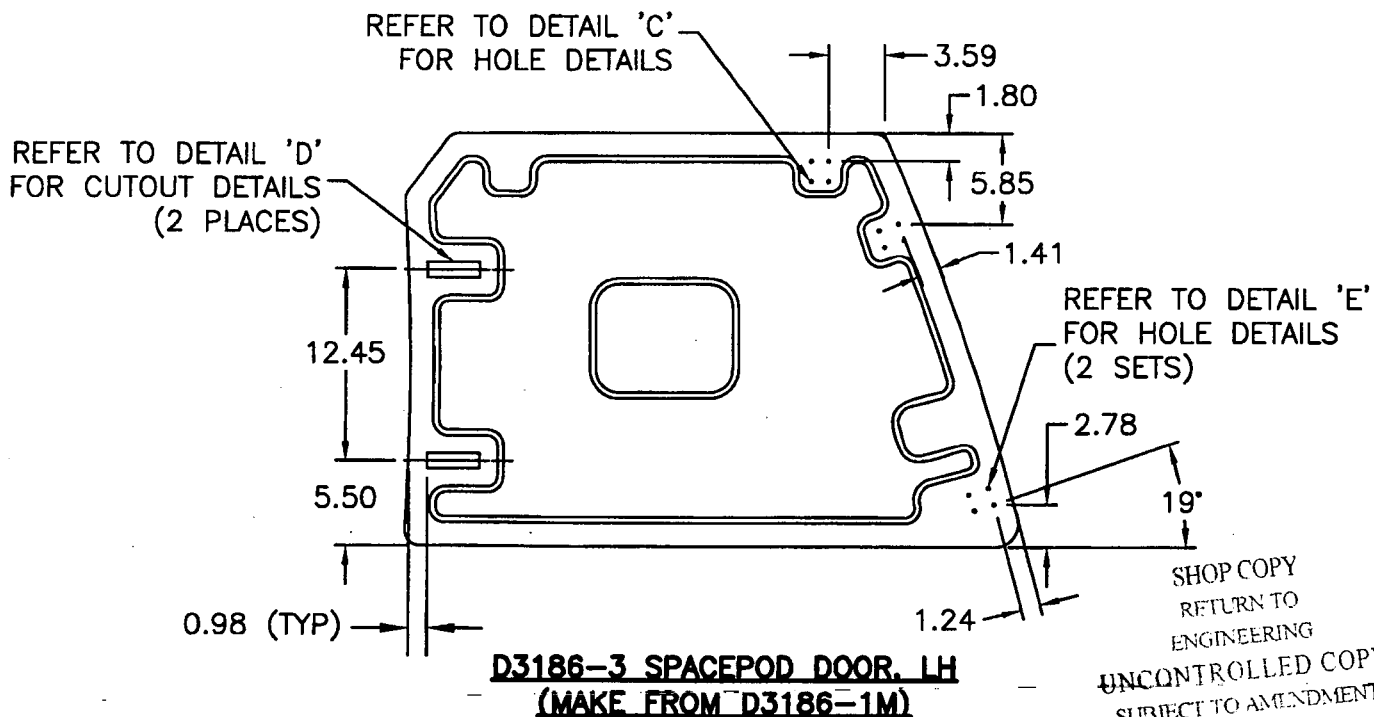
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

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FOR HOLE DETAILS  
(2 SETS)



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*06-22-13*

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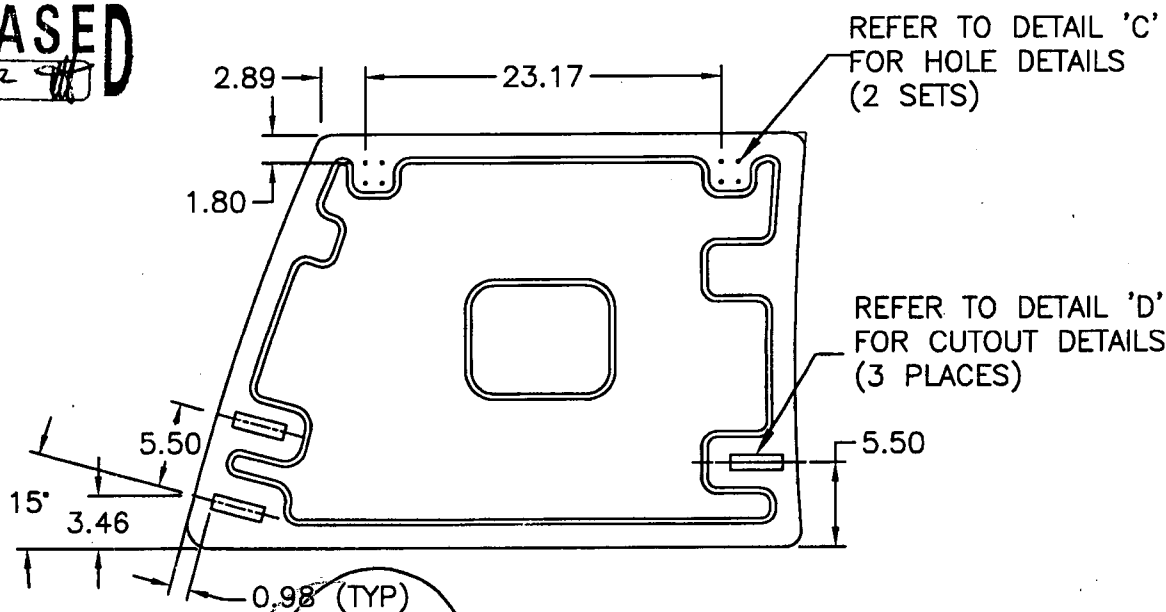
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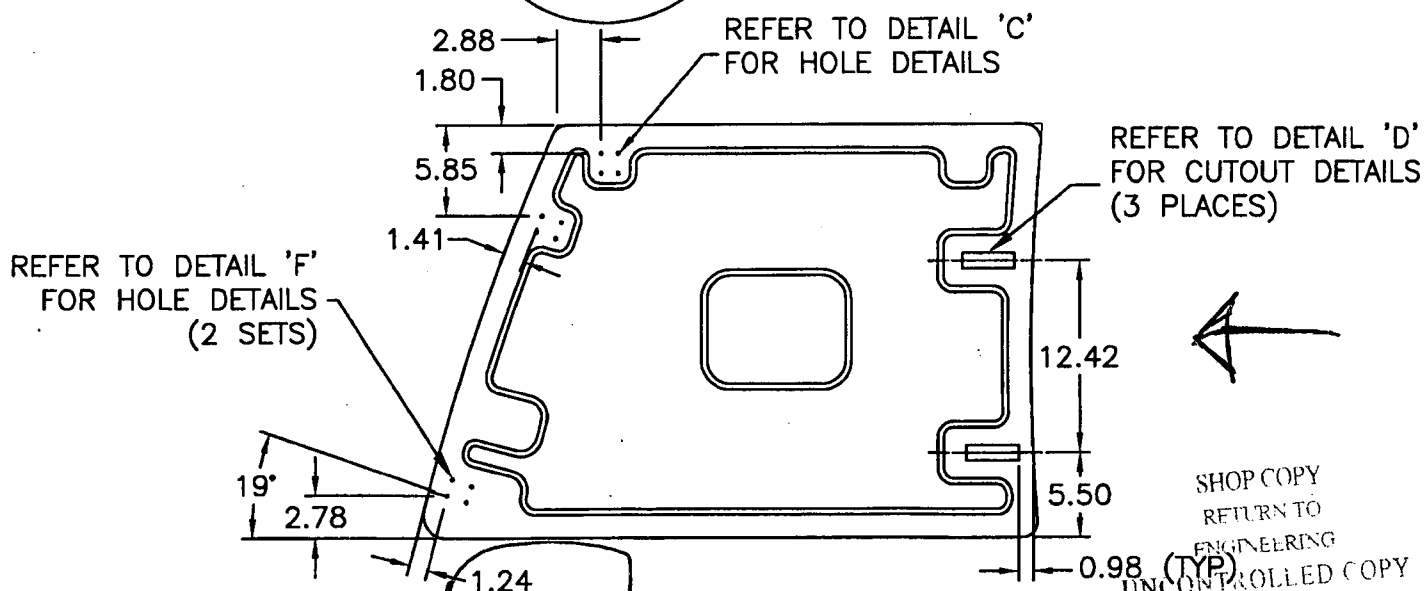


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

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06.12.22



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

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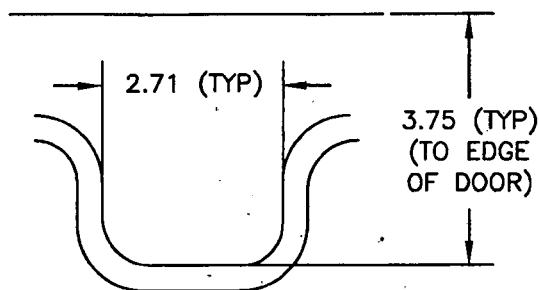
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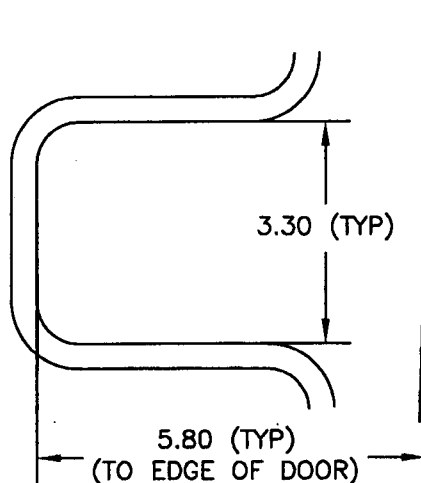
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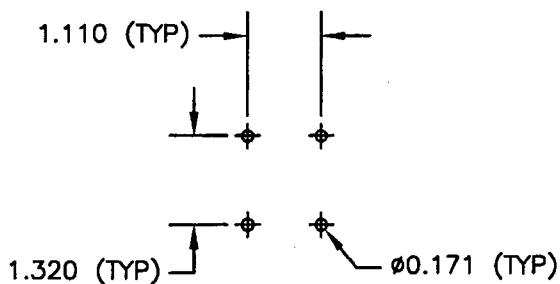
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



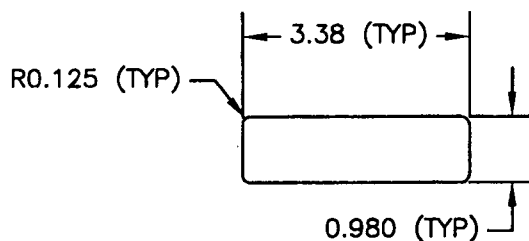
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**DETAIL B**

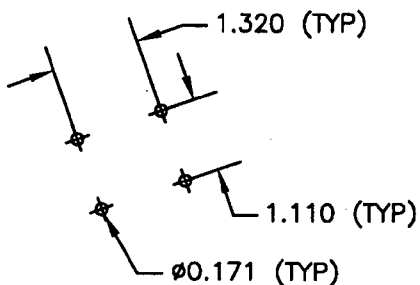


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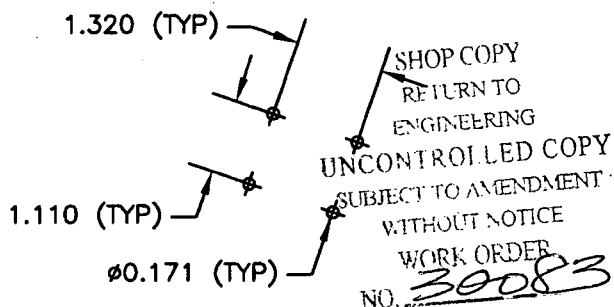


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

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06.12.22



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2699, 5<sup>ème</sup> Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12145
Customer #	DART

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Sales person	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard ext. 233	
Ship date	Order Date	Our PO #	Order by		Our PO #	ST/PST #	
05/09/2007	22/12/2006	5093	C. Lavoie		PQ00002771		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30083 Dwg. Rév.: D Job: 42018		U de M : Each	
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30088 Dwg. Rév.: D Job: 41316		U de M : Each	
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30073 Dwg. Rév.: D Job: 41325		U de M : Each	
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30078 Dwg. Rév.: D Job: 41308		U de M : Each	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

*Michel St/And*  
Quality department AQ-357



Date: Mardi, 14  
Utilisateur: Marc D

## Feuille de Procédé

Client: Dart Aerospace Ltd.

Numéro Job:

Numéro Soumission:

Numéro B.A.:

Cette fois: B.V.

Prêt Rev.:

Prem. fois:

Job précédente:

Écrit par:

Vérifié &amp; Approuvé par:

Commentaires:

Dart Aerospace 862M

Nom Dessin : SPACEPOD DOOR

Numéro Article : DKC134-0054

Numéro Dessin : D3186

Projet Numéro : DKC134

Révision Dessin : C

Matériel : Fibre 7781 et Résine 411-350

Date Dûe : 2007-07-17 Qté: 1 Udm: UN

Produit additionnel:

Numéro Job:

# Séq.:

Don:

Description :

1.0

Frekote 44NC

Commentaire: 0.020 GALLON(s)/Unit

: 0.020 GALLON(s)

2.0

PRÉPARATION DU MATÉRIEL DART

Commentaire: Hrs/Run: 5.0000Min

Run : 0.0833Hrs

MOULE

du moule N° 005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon

Heure Début: 7:00

Heure Fin: 12:00

Sceau:



3.0

Tissu à délaminer Release ply B

Commentaire: Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)

Tissu à délaminer Release ply B

4.0

AC0407

Wrighton 5200 Bleu P3

Commentaire: Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)

Wrighton 5200 Bleu P3

5.0

AC0408

Feutre de drainage N° Airweave N 10

Commentaire: Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

6.0

Stretchon 200 poche à vide Vert

Commentaire: Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

poche à vide Vert

Date: Mardi, 2007-07-10 08:32:14

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 4008

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération:

Description:

7.0 A0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire: 4.500 VERGE(s)/Unit Total: 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish #LOT: 2-6093-1

8.0 A0443 Fiberglass 12 oz Unidirectional

Commentaire: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-5964-1

9.0 A0098 Ruban à gommer jaune #: T/AT-200Y

Commentaire: 2.2500 RL(s)/Unit Total: 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

10.0 PRÉPARATION DU MATÉRIEL DART



Commentaire: Setup: 0.500Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

PRÉPARATION DU MATÉRIEL

Préparer le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchion 200 en laissant le papier sur le côté non en contact avec le sac à vent.

Pendant l'accélération du processus de séchage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

4/10/07 Heure Début: 12:00 Heure Fin: 3:00 Sceau:

11.0 A0275 Catalyst N° DDM-9

Commentaire: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)

Catalyst N° DDM-9 N° de Lot: 1-5921-3

12.0 Résine (411B7530) 411-350 promo. 75min.

Commentaire: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s)

(411B7530) 411-350 promo. 75min N° de Lot: 1-6228-1

13.0 PRÉPARATION DU MATÉRIEL DART



Commentaire: Setup: 0.0833Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par la résine N° 411-350.

2007 Heure Début: 2:25 Heure Fin: 2:25 Sceau:

Date: Mardi, 2007-07-10 08:32:14

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42018

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description:

14.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min. Total Run : 0.2500Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: JUL 09 2007

Heure Début: 2:25

Heure Fin: 2:40

Sceau:



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min. Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUL 09 2007

Heure Début: 2:40

Heure Fin: 2:50

Sceau:



Curing Début: 2:25

Curing Fin: 8:00

16.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6228-1

Date: Mardi, 2007-07-10 08:32:14

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42018

Numéro Article: DKC134-0054

Numéro Job:

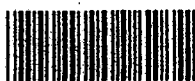


# Séq.: Machine ou Opération: Description :

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heure.

Date: JUL 10 2007

Heure Début: 8:45

Heure Fin: 9:00

Sceau:



19.0

AAC0452

Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)

Polybond B46F

N° de Lot: 1-6177-1

20.0

DKC134-0057

Foam Core N° D3186-102 ( Porte D3186-2 )

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-102 ( Porte D3186-2 )

N° de Job: 42017

21.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DES PIÉCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )

Faire l'inspection du positionnement par le département de la qualité

Date: 11-07-07

Sceau:



Initiales: H.S.

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: JUL 11 2007

Heure Début: 2:10

Heure Fin: 2:30

Sceau:



Date: Mardi, 2007-07-10 08:32:14

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42018

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

22.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond

Date: JUL 11 2007 Heure Début: 2:30 Heure Fin: 2:40 Sceau:  

Curing Début: 2:10 Curing Fin: 3:30

23.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-618-3

24.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6228-1

25.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: AUG 02 2007 Heure Début: 10:30 Heure Fin: 10:35 Sceau: 



Date: Mardi, 2007-07-10 08:32:14

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42018

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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26.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: AUG 02 2007 Heure Début: 10:35 Heure Fin: 11:05 Sceau:



27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min -Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: AUG 02 2007 Heure Début: 11:05 Heure Fin: 11:20 Sceau:



Curing Début: 10:35 Curing Fin: 3:00

28.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabier la surface de la pièce qui était en contact avec le le moule afin d'éliminer le fini lisse de celui-ci.

Date: 02-07 Heure Début: 3:15 Heure Fin: 3:20 Sceau:



Date: Mardi, 2007-07-10 08:32:14

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42018

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: 02-07-07 Heure Début: 3:20 Heure Fin: 3:45 Sceau:

30.0	AAC0671	Dupont Primer N° 1104S
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Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S

N° de Lot: 1-6149-1

31.0	AAC0670	Dupont Activation N° 7975S
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Commentaire Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activation N° 7975S

N° de Lot: 1-6065-1

32.0	AAC0672	Dupont Reducer N° 12375S
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Commentaire Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S

N° de Lot: 1-6065-3

33.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

AUG 09 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Appliquer une première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application primer

Laisser sécher pendant 3 heures.

Date: Mardi, 2007-07-10 08:32:14

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42018

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description:

Date: AUG 09 2007 Heure Début: 9:00 Heure Fin: 9:30 Sceau:

35.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

AUG 15 2007



Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6227-1

37.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

38.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: 15-8-07 Heure Début: 2:30 Heure Fin: 4:00 Sceau:

39.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6149-1

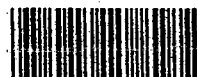
40.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTÉ(s)/Unit Total : 0.2800 PINTÉ(s)  
Dupont Activator N° 7975S N° de Lot: 1-6254-1

41.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-5769-3

42.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

AUG 16 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

Date: Mardi, 2007-07-10 08:32:15

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42018

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
APPLICATION DE PRIMER

Appliquer une deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application de primer.

Date: AUG 16 2007

Heure Début: 2:40 Heure Fin: 3:00



44.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
INSPECTION PIÈCE DART

Inspection des pièces par le département de la qualité

Quantité: 1 Date: 27-07-07

Sceau:



P.S.

Quantité: Date: Sceau:

45.0 EMBALLAGE EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 31/8/07

Sceau:



Quantité: Date: Sceau:



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12113
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

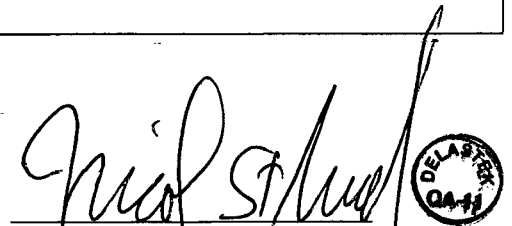
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
22/08/2007	22/12/2006	5093	C. Lavoie		PO00002771		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30084 Dwg. Rév.: D Job: 41334			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30089 Dwg. Rév.: D Job: 41315			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30074 Dwg. Rév.: D Job: 41324			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30079 Dwg. Rév.: D Job: 41307			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

  
Quality department


AQ-357



Date: Jeudi, 2007-03-29 10:33:36  
Utilisateur: Marc Dubé

## Feuille de Procédé

Cliant	: DART Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD BODY
Numéro Job	: 41315	Numéro Article	: DKC134-0055
Numéro Soumission	: 2587	Numéro Dessin	: D3188
Numéro B.A.	:	Projet Numéro	: DKC134
Cette fois	: 2007-03-29 No. B.V. :	Révision dessin	: B
Prsht Rev.	: NC	Matériel	: Fibre 7781 et Résine 411-350
Prem. fois	: - - Type :	Date Dûe	: 2007-04-05 Qté: 1 Udm: UNITE
Job précédente	: 41314		

Écrit par : 

Vérifié & Approuvé par : \_\_\_\_\_

Commentaires : N° de pièce Dart Aerospace : D31882M

Process Sheet Rev.: 01 Modification générale selon les informations de l'ingénierie

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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1.0	AC0303	Frekote 44NC
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Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 13/07/07 Heure Début: 7:30 Heure Fin: 11:00 Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)  
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)  
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)  
Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)  
Stretchlon 200 poche à vide Vert

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41315Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire Qty.: 11.400 VERGE(s)/Unit Total: 11.400 VERGE(s)  
9.7 oz Weave #FG-778150-125Y Volan Finish

# LOT: 1-6170-2

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentaire Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s)  
Fiberglass 12 oz Unidirectional N° de Lot: 1-5964-1

9.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentaire Qty.: 0.35 VERGE(s)/Unit Total: 0.35 VERGE(s)  
WR1850 ROVING 18 OZ x 50" N° de Lot: 1-6113-1

10.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 4.0000 RL(s)/Unit Total: 4.0000 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs  
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 4/06/07 Heure Début: 8:00 Heure Fin: 12:00 Sceau: 32

12.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)  
Catalyst N° DDM-9 N° de Lot: 1-5921-3

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total: 2.000 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6228-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0039 GALLON(s)/Unit Total: 0.0039 GALLON(s)  
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Jeudi, 2007-03-29 10:33:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

JUL 30 2007

Date:

Heure Début: 8:30

Heure Fin: 8:40

Sceau:



16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

JUL 30 2007

Date:

Heure Début: 8:40

Heure Fin: 9:10

Sceau:



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

JUL 30 2007

Date:

Heure Début: 9:10

Heure Fin: 9:30

Sceau:



Curing Début: 8:30 Curing Fin: 1:00

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentaire Qty.: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

19.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

TAILLAGE DU MATÉRIEL

Tailler le Foam Core 1" selon le plan de découpe et les gabarits

Date: AUG 01 2007

Heure Début: 12:30

Heure Fin: 2:30

Sceau:



20.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6228-1

21.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-618-3

22.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

FINITION PIÈCE DART

AUG 01 2007



Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

23.0

AAC0452

Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)

Polybond B46F

N° de Lot:

1-6177-1

24.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

FINITION PIÈCE DART

À l'aide du Polybond, coller ensemble les deux surfaces scellées

Disposer des point sur les pièces pour conserver une pression de collage.

Laisser sécher pour un minimum de deux heures.

Quantité: 1

Date: AUG 01 2007

Sceau:



Date: Jeudi, 2007-03-29 10:33:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1

Date: AUG 01 2007

Sceau:



Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6228-1

27.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)  
Catalyst N° DDM-9

N° de Lot:

1-6118-3

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

AUG 01 2007

AUG 02 2007

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par  
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART

Commentaire Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs  
FABRICATION GÉNÉRALE PLASTIC COMMERCIAL

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.

Laisser sécher pendant 2 heures minimum.

Date: AUG 02 2007

Sceau:



Initiales:

C.G.

# Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41315

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération:

Description :

30.0 AAC0452 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)  
Polybond B46F N° de Lot: 1-6177-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond

Date: AUG 02 2007 Heure Début: 12:45 Heure Fin: 12:55 Sceau:



32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: AUG 02 2007 Heure Début: 12:55 Heure Fin: 1:15 Sceau:



33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs  
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: AUG 02 2007 Heure Début: 1:15 Heure Fin: 1:30 Sceau:



Curing Début: 12:55 Curing Fin: 2:10

ate: Jeudi, 2007-03-29 10:33:37

Utilisateur: Marc Dubé

## Feuille de Procédé

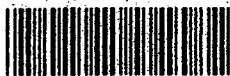
Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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34.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens
------	--------	----------------------------------

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100.UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6227-1

35.0	AC0059	Durcisseur Polysoft #004009 Sikkens
------	--------	-------------------------------------

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

36.0	FINITION 3	FINITION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polybond

Date: AUG 06 2007 Heure Début: 7:30 Heure Fin: 10:00 Sceau:



37.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
------	-----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

AUG 06 2007



Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

38.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6251-1

39.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6118-3

40.0	FINITION 3	FINITION PIÈCE DART
------	------------	---------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

AUG 06 2007



Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core

Laisser sécher pendant minimum deux heures.

Date: Jeudi, 2007-03-29 10:33:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

Date: AUG 06 2007

Heure Début: 2:15

Heure Fin: 2:40

Sceau:



Curing Début: 1:35

Curing Fin: 8:00

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: AUG 07 2007

Heure Début: 9:50

Heure Fin: 16:00

Sceau:



47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

TRIMAGE DE FINITION

Perçer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, perçer les 8 dégagement de  $\varnothing .745"$  pour les spacers N° D2213 ( ne pas perçer la peau extérieur de la pièce )

Date: AUG 07 2007

Heure Début: 12:30

Heure Fin: 1:30

Sceau:



48.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-618-3

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6251-1

50.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

Date: Jeudi, 2007-03-29 10:33:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description:

51.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIELFaire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par  
quantité de résine N° 411-350.

2007 6 0 9 2007

Date:

Heure Début:

7:30

Heure Fin:

7:35

Sceau:



52.0

AAC0448

Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total: 8 UNITE(s)

Spacer N° D2213

N° de Lot:

1-5949-1

53.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÉCESFaire l'assemblage des inserts ( Spacer ) N° D2213 dans les trous prévus à cet effet à l'aide de résine N°  
411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.

Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous

Appliquer un pression sur les pièces de 9 ox à l'aide d'un bloc de bois et de pinces autobloquantes

Laisser sécher pendant 4 heures minimum.

AUG 0 9 2007

Date:

Heure Début:

7:35

Heure Fin:

8:35

Sceau:



Curing Début:

7:35

Curing Fin:

11:35

54.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-6118-3

55.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6251-1

Date: Jeudi, 2007-03-29 10:33:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

56.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: AUG 08 2007Heure Début: 10:15 Heure Fin: 10:20 Sceau: 

57.0

LAMINAGE.

LAMINAGE PIÈCE DART





Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièces. Selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: AUG 08 2007Heure Début: 10:20 Heure Fin: 11:20 Sceau:  Curing Début: 10:20 Curing Fin: 2:20

58.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

FINITION PIÈCE DART

① Repercer les 8 trous des spacers afin de les déboucher AUG 09 2007 ② Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections. 13-8-07 

59.0

AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)

Dupont Primer N° 1104S

N° de Lot: 1-6149-1

60.0

AAC0670

Dupont Activation N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)

Dupont Activation N° 7975S

N° de Lot: 1-6065-1

Date: Jeudi, 2007-03-29 10:33:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description:

67.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total: 0.2500 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6149-1

68.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total: 0.5000 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6065-1

69.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-5769-3

70.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

AUG 14 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

71.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs  
APPLICATION DE PRIMER

Appliquer deux couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.

Laisser sécher pendant 3 heures minimum

Date: AUG 14 2007

Heure Début: 5:30 Heure Fin: 6:00 Sceau:



72.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 15-07-07

Sceau: DELASTIK QA-11

Initiales: N.S.

73.0 EMBALLAGE 3 EMBALLAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
EMBALLAGE PIÈCE DART

Faire l'emballage dans le contenant approprié.



Date: Jeudi, 2007-03-29 10:33:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41315

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 15/8/07 Sceau:

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

Thursday, 12/21/2006 12:55:26 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY RH
Job Number	: 30089		
Estimate Number	: 12596		
P.O. Number	: N/A	Part Number	: D31882M
This Issue	: 12/21/2006 S.O. No. : N/A	Drawing Number	: D3188 REV <i>BC</i> <i>16 07.01.18</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : PURCHASED PARTS	Drawing Revision	: <i>BC</i> <i>16 07.01.18</i>
Previous Run	: 30088	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 2/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: A New issue ecn882 06-11-30 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Ship To Delastek

8 D2213 Spacer Batch: *B30049*

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2771*

Description: D3188-2M BODY

SHIP: D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

*(41315)*

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

*12/18/24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 8/12/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/21/2006 12:55:26 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 30089

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



(PTO)



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

ml 07/11/02

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/11/02

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 07/12/06

Job Completion

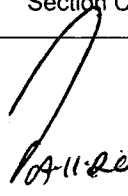
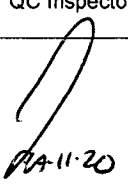


U 07.12.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.11.20	S.O	Qty - pods have thicker rib (section C-C on drawing)	UE 07.11.20 QS1042	Acceptable. Substitute w/ longer screws at assembly.	UE 07.11.20	 07.11.20	UE 07.11.20 QS1042	 07.11.20

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 1 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	

**GENERAL NOTES:**

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

**3. MATERIALS:**

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL

FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

**4. MOLD SCHEDULE:**

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES
8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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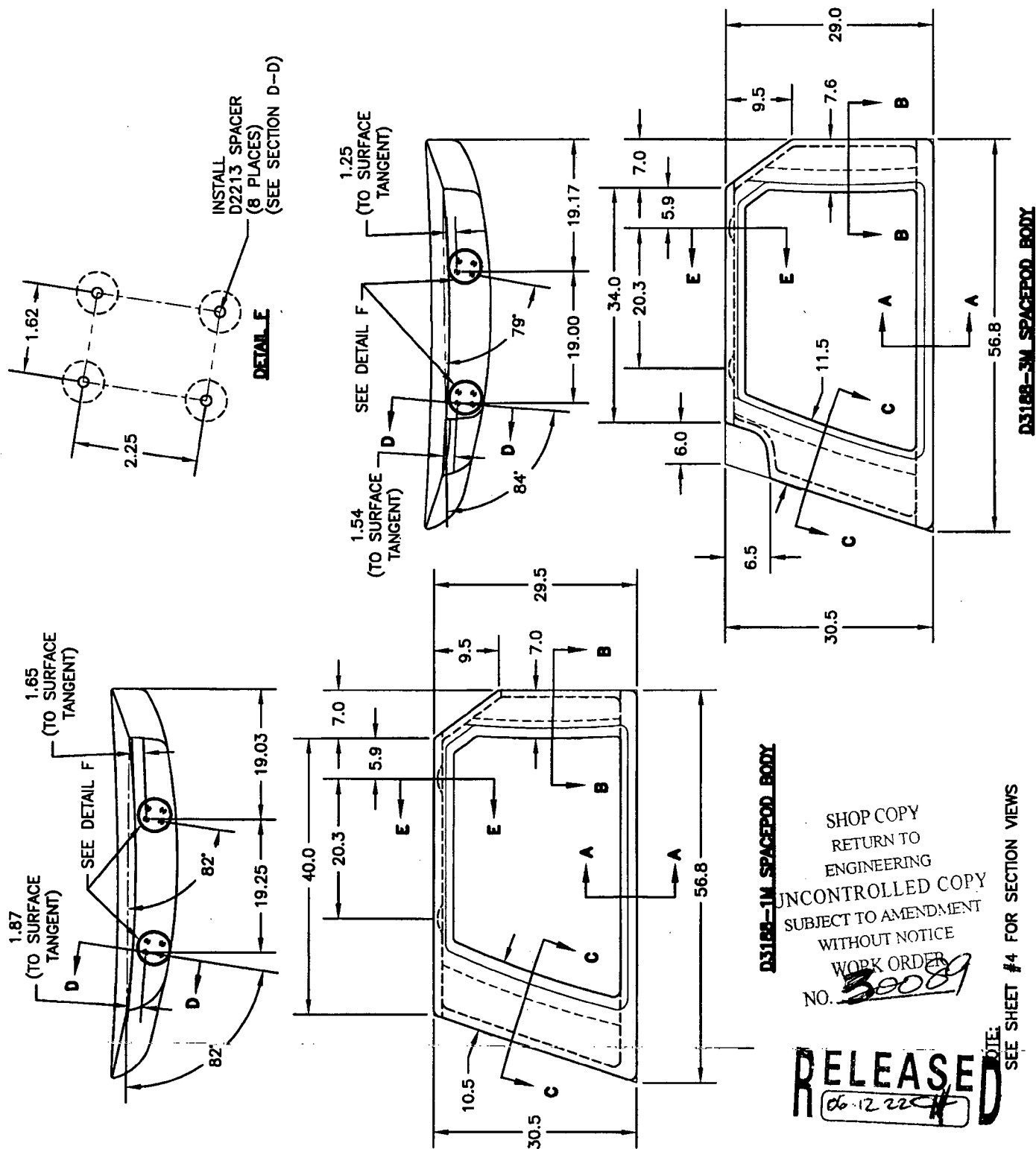
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06.12.22

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DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 2 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



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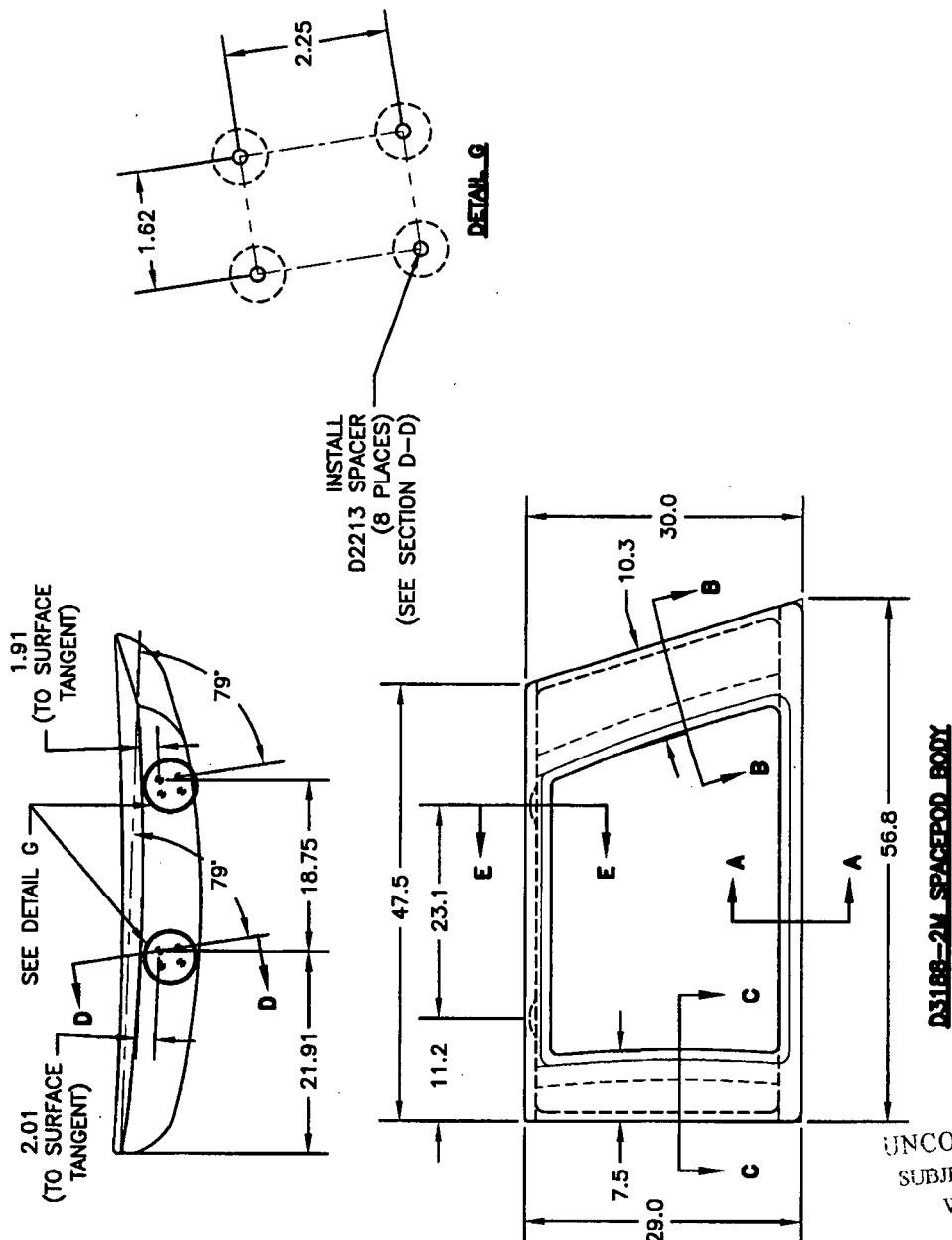
NOTE:  
SEE SHEET #4 FOR SECTION VIEWS

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DATE <b>06.12.13</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS



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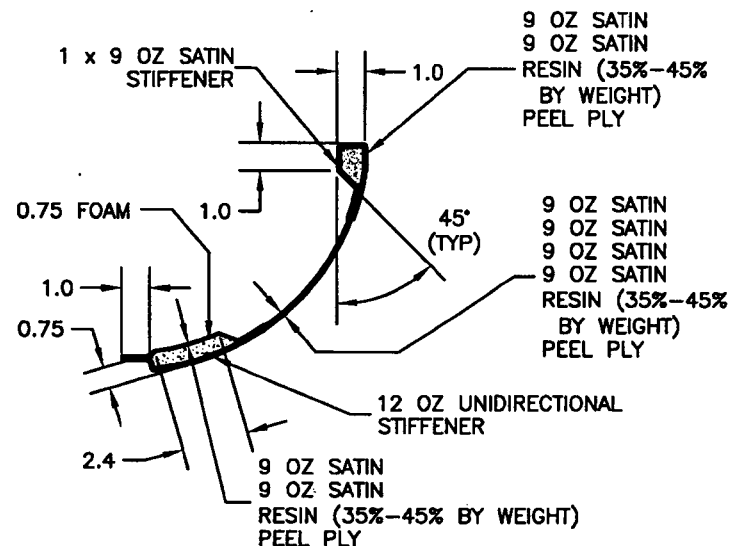
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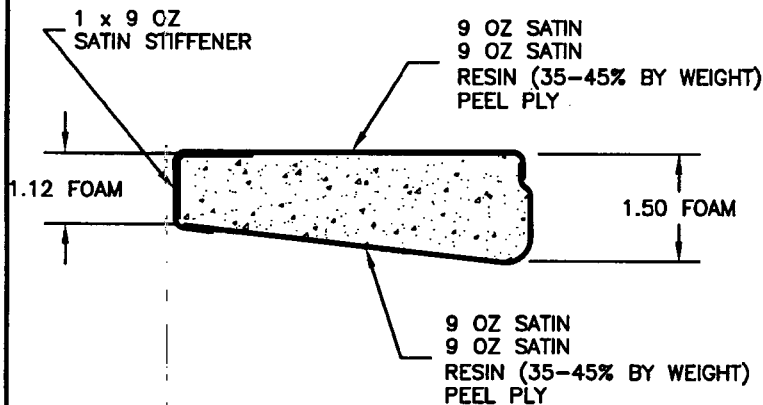




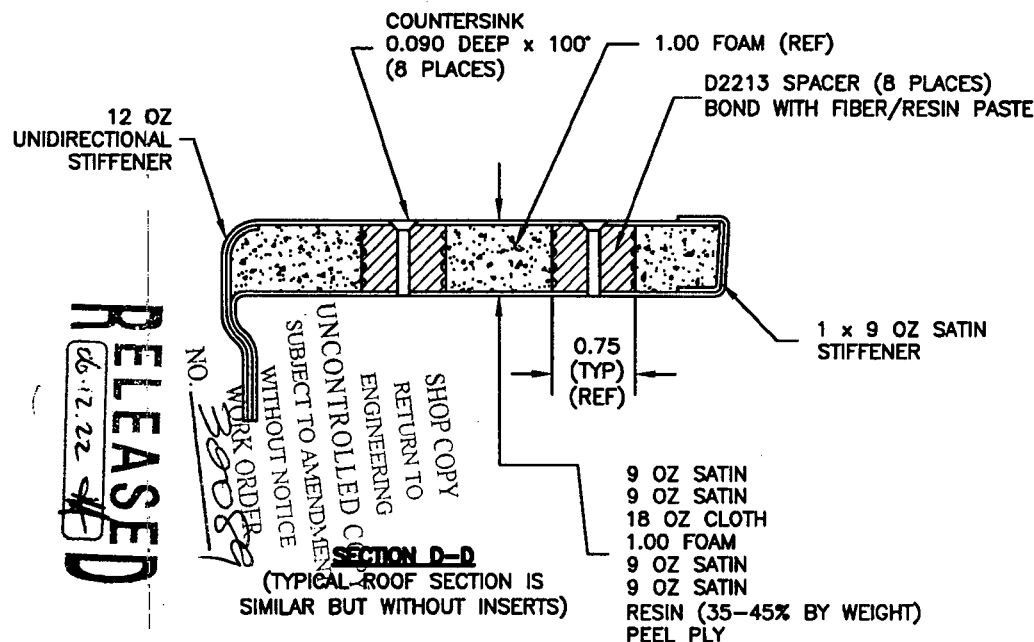
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DATE	06.12.13	DRAWING NO.	D3188	REV. C
		TITLE	SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS



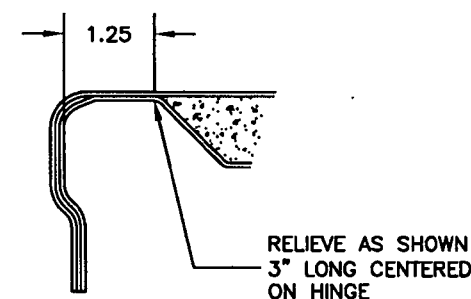
SECTION B-B  
(SECTION C-C OPPOSITE)



SECTION A-A  
(TYPICAL FLOOR SECTION)



SECTION D-D  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



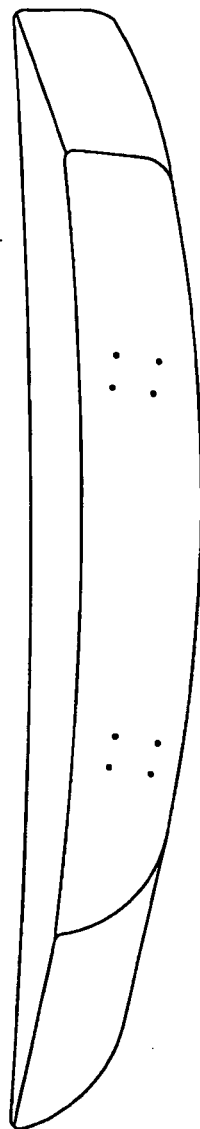
SECTION E-E  
(2 PLACES PER POD)

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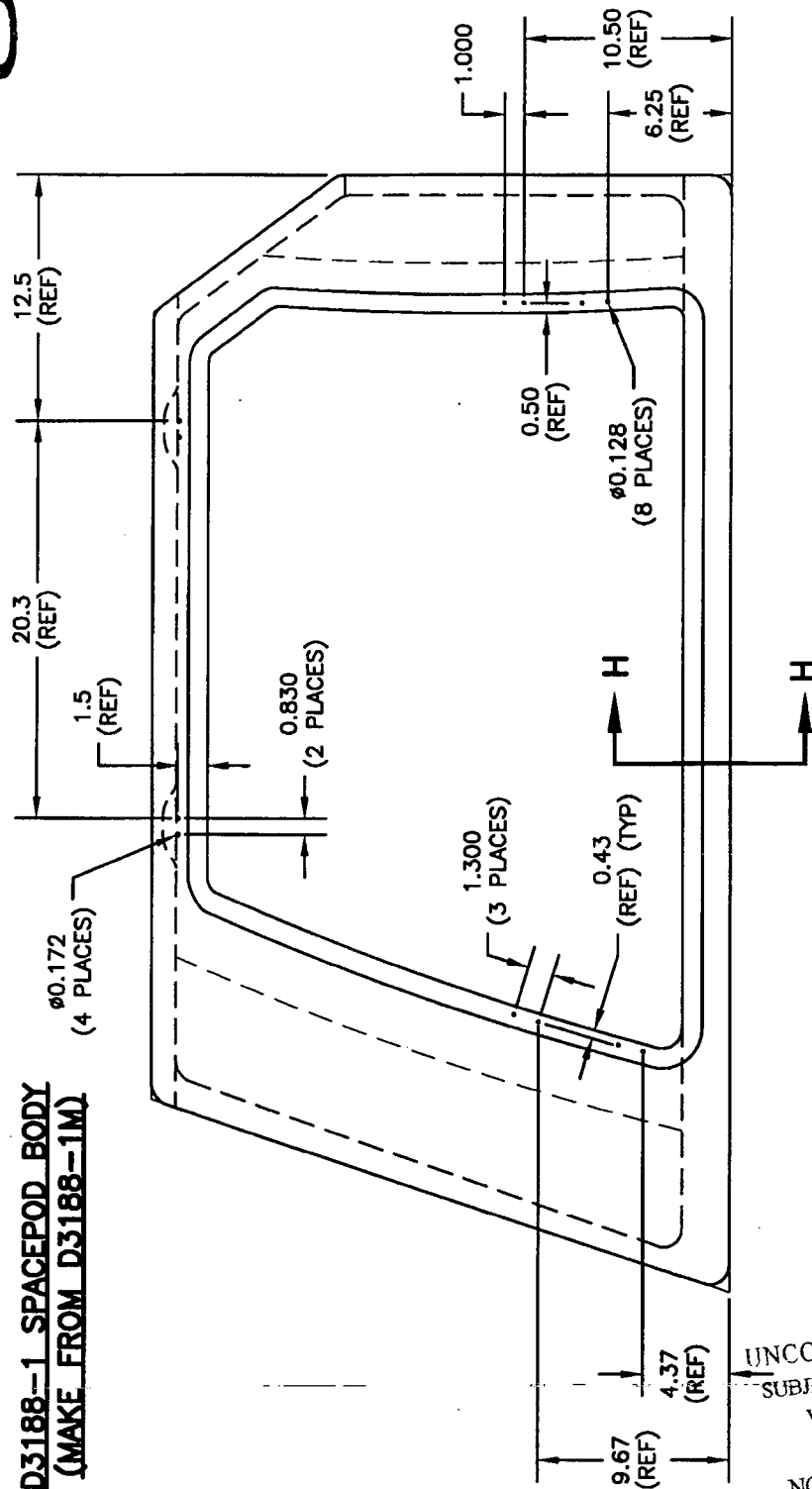


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**D3188--1 SPACEPOD BODY  
(MAKE FROM D3188--1M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186--1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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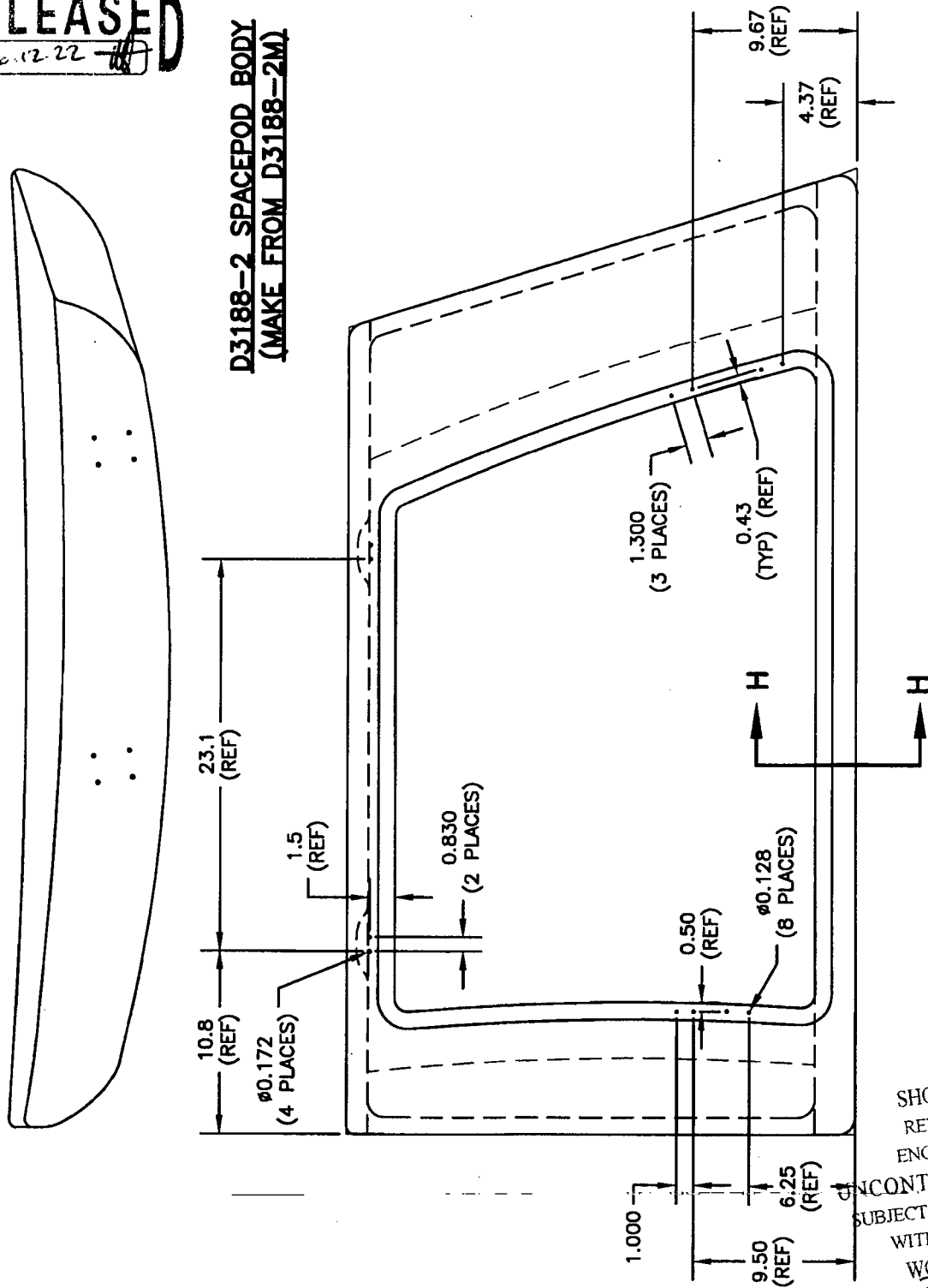
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-2 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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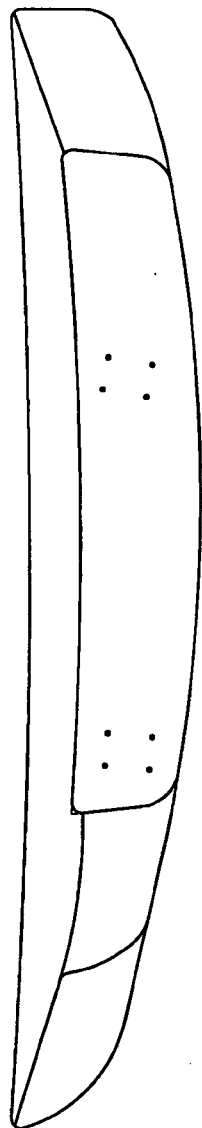
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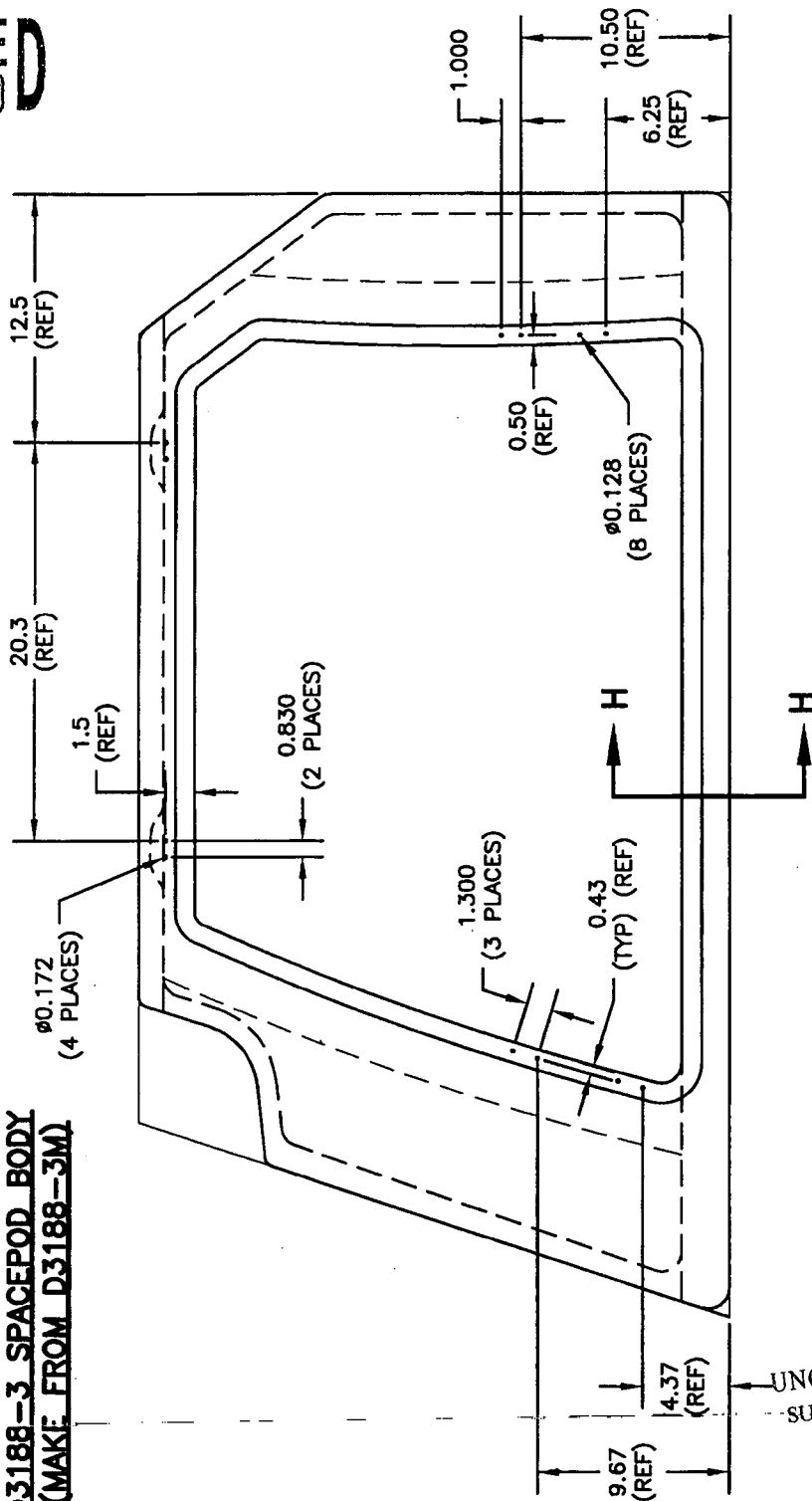


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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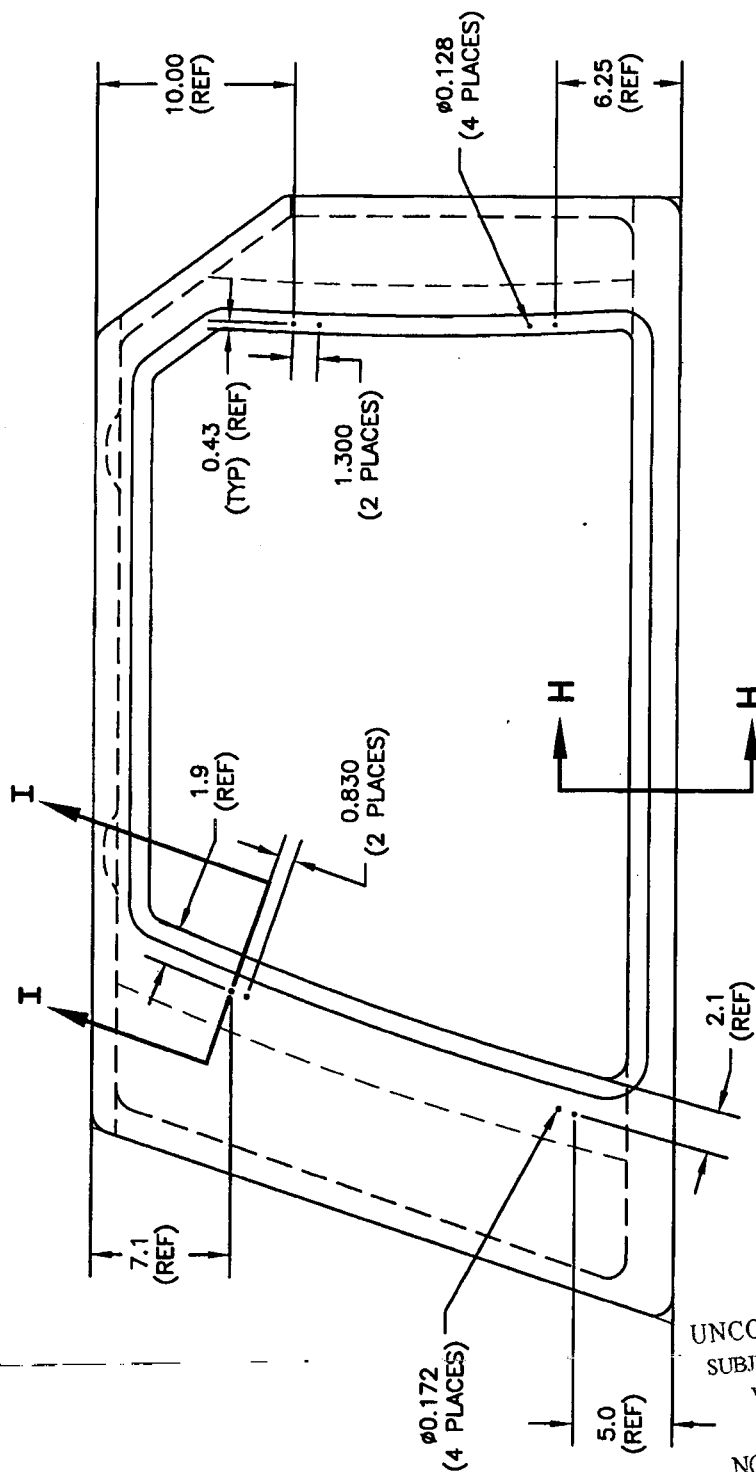
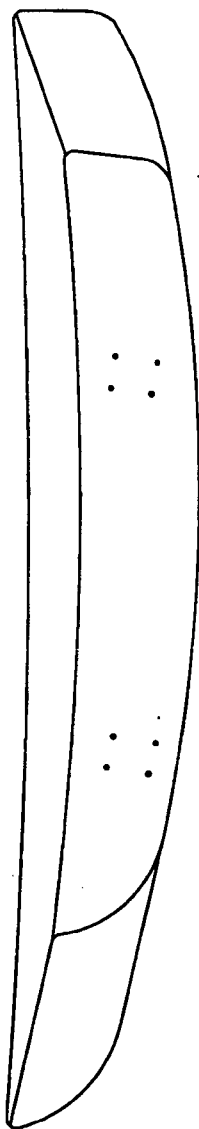
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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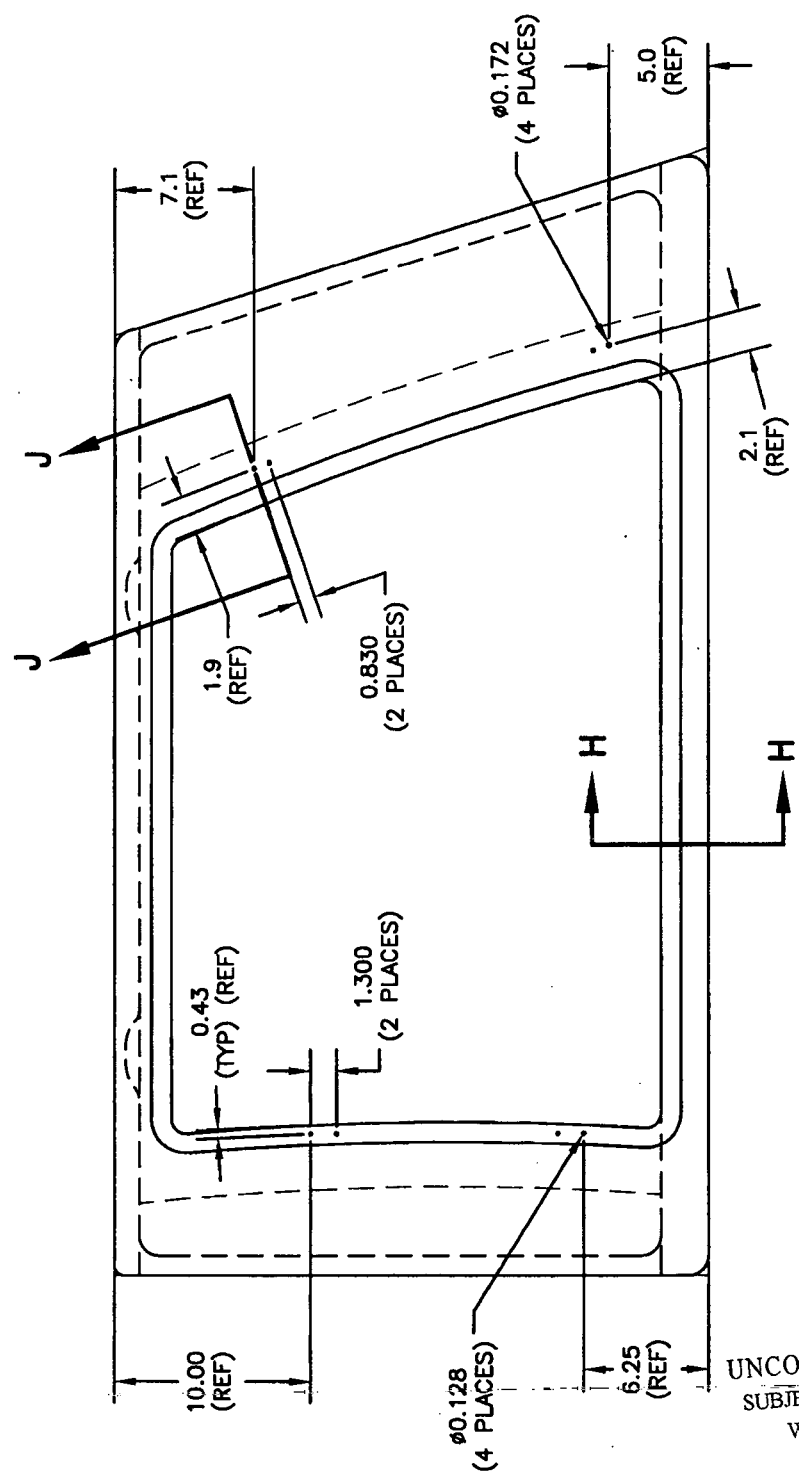
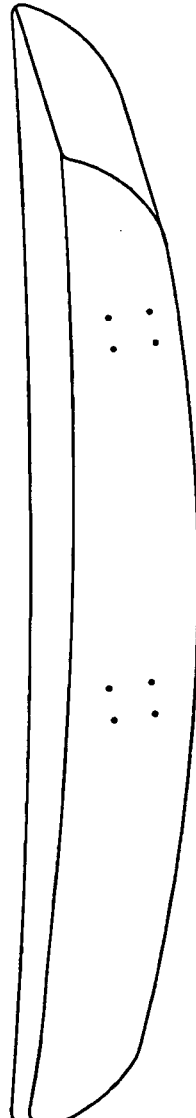
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEWS

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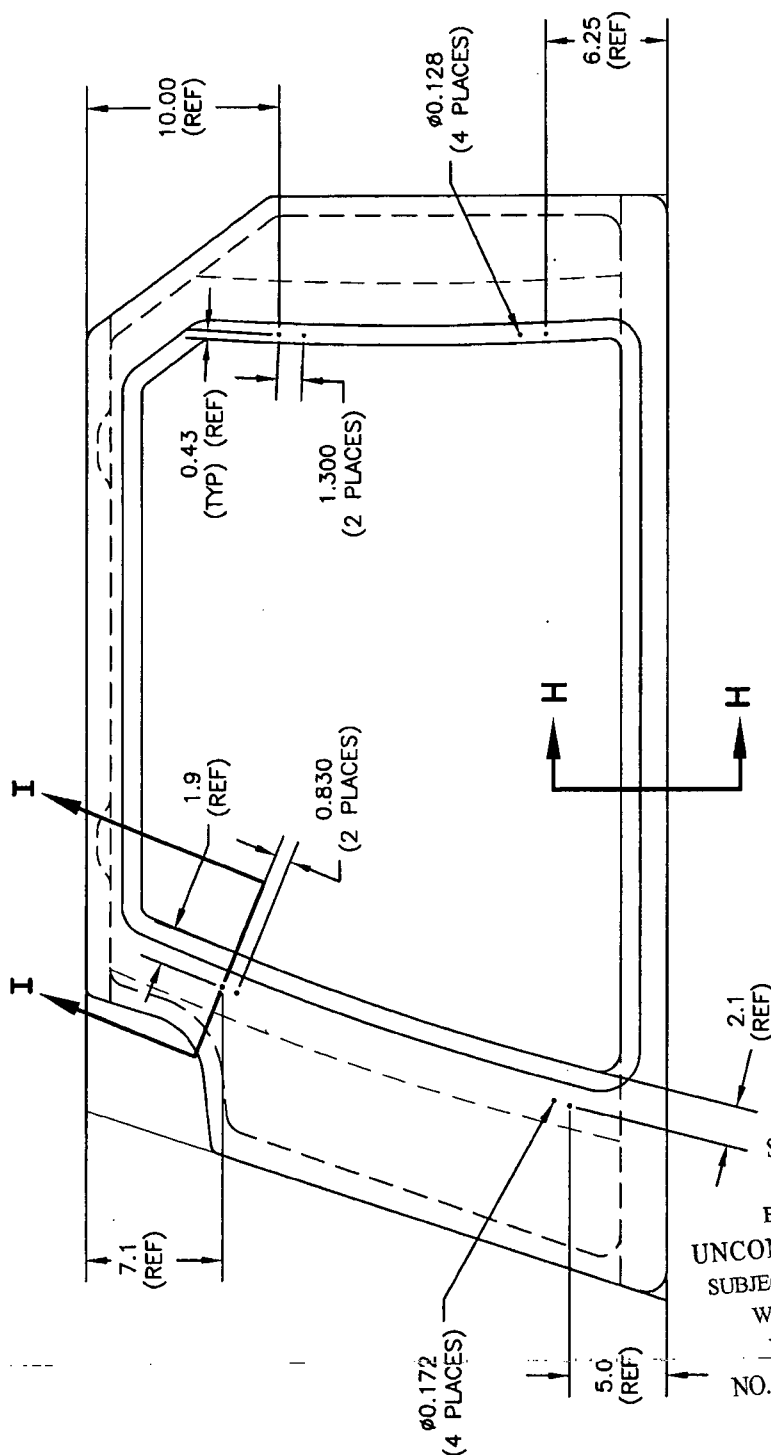
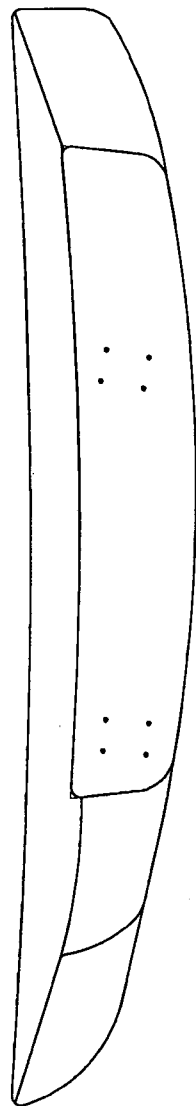
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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

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D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)



NOTE:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

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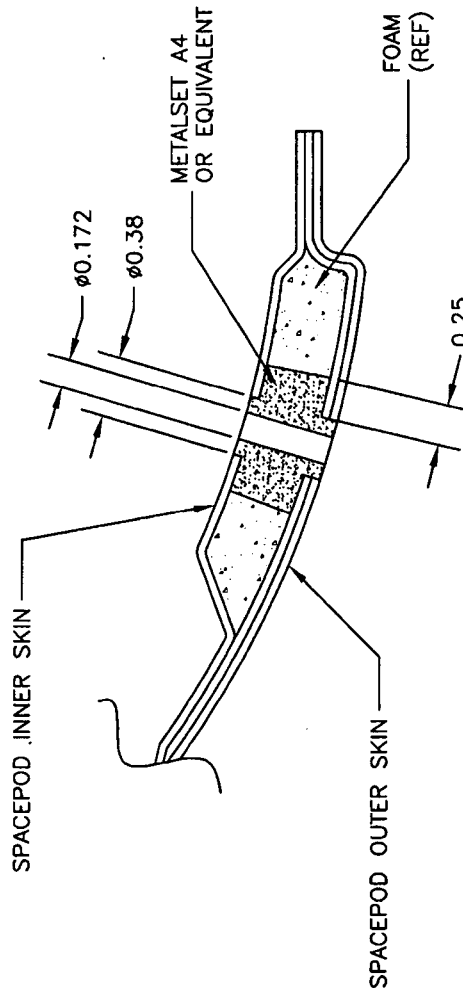
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INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



SECTION H-H  
(TYPICAL FLOOR SECTION)



SECTION I-I  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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